

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004019**Date Inspected:** 13-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang, Jiang Jian Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** tower skin assemblies,deck panels**Summary of Items Observed:**

Tower shop - Bay 1

QA Inspector randomly observed approximately 50 ZPMC workers performing the following: flame heat straightening and flame cutting of bevels on plates; grinding of tacks on stiffener to SSD1-B lap assembly; electric preheat and FCAW-G fill pass of stiffener to SSD1-E lap assembly in the tilted up position; SAW of cover pass at SSD1-SA171A/D-7A; FCAW-G repair of SSD1-SA164A/F-6A per welding repair report T-WR248; FCAW-G automatic fill passes, with four welders on south-west gantry on stiffener to SSD1-skin D assembly. Also present in this bay were ZPMC CWI's Xu Le Feng and Li Yang as well as ABF QC's Yang Yi Heng, and Zhang Qin Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 40 ZPMC workers performing the following: grinding of root or fill passes of stiffener to ESD1-skin C assembly; ZPMC UT of stiffener to ESD1-A assembly welds; preheat and SMAW tack of stiffener to ESD1-C lap assembly welds. Also present in this bay were ZPMC CWI Jiang Jian Fei as well as ABF QC Luo Lai Quan. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed 3 ZPMC workers performing the following: grinding of U-rib to deck panel welds on DP553-001. There were 20 full size panels, 2 half size panels, and several unidentified deck plates in various stages of butt welding present in the bay. No welding was observed being performed. Items observed appeared to comply with project specification.

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Summary of Conversations:

No significant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
